Work Orde	er ID 100384 3:11 PM			*100	1384*			Page 1
Revision ID: Item Name:	_	ety: 1.00 Qty: 1.00	*1* *1*	Accept 3x	*N90002 Cust Item ID: Customer:	4 0100 *	Setup Start	*NS2*
Approvals:	Process Plan: M.	_5	D - 4	, k	Date:		Run Start	"INK I"
Sequence ID/ Work Center II	Operati Descrip			Set Up/ Run Hours	Tool ID To	ool# Plan Acce Code Qty	pt Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nb	r						
D3852	Rev A	j						
*100 *100* Large Fab Large Fab	Large Fab	Memo	66-3 to cut D3852-1 rib (0.00 0.00 LH) as per dwg D3852 us	sing DT9440 jig	3) 13	-10-15 mA
		dwg D3852 3- c'sink hol	(3/16") in D3852-1 using e as per dwg lentification markings	DT9439 jig and open to	finish size as per			
		5- deburr			SA) 13-09-	26		·
		6- weld D37 A/R ER310	59-1 bushing as per dwg 6 S.S. Rod Batch:			- 0	e e e e e e e e e e e e e e e e e e e	
		7- grind bus	hing weld flush as per dv	vg dwg D3852		•		
		8- deburr ho	le if necessary			•	Marketon Company	

											DQA:	Date:	
NCR:	res /	No				WORK ORDER NON-C	O	NFORM	MANCE / UPDATE		QA Closed:	Date:	
Work Orde	-r:					DISPOSITION			AGAINS	r DE	PARTMENT	PROCESS	
Part N	No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		ate	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data							П						
Equip/Tooling											,		
Operator													
Material													
Setup							1						
Other	П												
Process													
Supplier						i e	l						
Training													
Unapproved													
,						F	AUL	T CATE	GORY			····	
Landi	ng Gea	r			_	General	_	-			-		•
	Bei	nding				Bend		Grain		L	Ovalized		Pressure/Forced
	Cei	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cra	cks				Broken/Damaged	Inspecti	on Incomplete		Part Incorred	t	Weld	
	Cru	ished/0	Crimped			Burrs			Instructions Incomplete/Unclear			ssing	Wrong Stock Pulled
	Cu	ffs		Contamination				Maintenance					
	He	at Trea	H :					Mislabe	eled		Positioned V	/rong	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Orde April-22-13 1:0		0384		*1	0038	34*					·		Page 2	2
Revision ID: Item Name: Start Date:	D3852-041 Rib Assembly 4/22/13	Start Qty: 1.00	*1*	Accept		1900 Cust Item II		100)*	Setup	Start Stop		S1* S2*	
Required Date: Reference:	4/22/13	Req'd Qty: 1.00	/ *1*			Customer:								
Approvals:	Process Pla	n:	Date:	_):		te:			Run	Start Stop	*NI *NI	R1*	
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC10- Inspect visual per	r QS1004- ground welds	Set Up, Run H 0.00	ours	Tool ID	Tool#	Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
140 *140* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00	GI,	3,10,	16		3 _x		"			-
150 *150* Packaging	·	Identify as per dwg & St	ock Location: which	0.00	CPC	13.10	שוים	٠.	.3 _X					-

Packaging

	DQA:	Date:	
MARK ORDER MON CONTORNATION / MRS ATE			

NCR:	·												
						T			*		QA Closed:	Date	<u> </u>
Work Ord	er: _		٠.			DISPOSITION	7			AGAINST DE	PARTMENT,	_	
Part !	-					Rework Scrap Use-as-is		•	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	۷o. ₋					Work Order Update			Large Fab	Composite		Supplier	
Root					1	ption of work order update		Initial	Acti		Sign &	_	
Cause		Date	Step	Qty	(or Non-conformance	CI	hief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling	Н		<u> </u>										
Operator	H												
Material	Н												
Setup	H		1										
Other	H				ĺ			_					
Process	Н		İ			* •		j					
Supplier	Н												
Training	Н												
Unapproved	Н				1								
				1	L	**	FAU	LT CATE	GORY		1,		*
Landi	ing G	iear			7	General		ţ					
		Bending			" Г	Bend	Г	 Grain			Ovalized	Γ	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	at [Weld
	П	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs	•			Contamination	Maintenance				Part Moved		·
		Heat Trea	at .		*	Countersink	Mislabeled				Positioned V	Vrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples in	•			Drill Holes		Offset				_	
				es in Extrusion Drawing				Out of Calibration					

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

a= .						2			
Work Ord <i>April-22-13 1:0</i>		0384		*100)384*				Page 3
Item ID: Revision ID: Item Name:	D3852-041 Rib Assembly	7. 2 		Accept	*N900	<u>040100</u>)* Set	up Start Stop	*NS1* *NS2*
Start Date: Required Date:	4/22/13 4/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:) :			
Reference:					•		_	0.4	
Approvals:		in:	Date:			te:	Ru	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection	· Work Order Release	Set Up/ Run Hours	Tool ID	Tool # Plan Code		•	Reject Insp. Number Stamp

0.00

Memo

160

Quality Control

A) AB-10-17

										L	QA:	Date	!:
NCR: Y	res / N	0			WORK ORDER NON-	COI	NFORN	MANCE / UP	PDATE	QA Clo	sed:	 Date	:
		·	"- ""	· · · · · · · · · · · · · · · · · · ·	DISPOSITION				AGAINST D	-			
Work Orde	er:				Rework	٦ أ	1	Skid-tube	Crosstube	7		Water Jet	Engineering
Part N	lo				Scrap Use-as-is	Scrap Machining Small Fab						d. Eng. Coor. re/Packaging	Quality
NCR N	No	-			Work Order Update	1		Large Fab	Composite]	, 515.	Supplier	
Root				Descri	ption of work order update		Initial	Ac	ction	Sign	&		
Cause	Dat	e Step	Qty		or Non-conformance	Ct	nief Eng Description			Dat	e	Verification	QC Inspector
Doc/Data													
Equip/Tooling			1										
Operator													İ
Material													
Setup			Ì										
Other			1	ĺ									
Process													
Supplier						1							
Training											,		
Unapproved			<u> </u>			1_			· · · · · · · · · · · · · · · · · · ·				
						AUI	LT CATE	GORY				_	
Landi	ng Gear			_	General		_		_	_		_	_
	Bend	ng		<u>. </u>	Bend	L	Grain			Ovalize	d	_	Pressure/Forced
	Centr	Not Conce	entric to	o/s	BOM/Route		Hardwa	re		_Over/U	nder	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged		Inspecti	on incomplete		Part Inc	corre	ct _	Weld
	Crush	ed/Crimped	i		Burrs		Instruct	ions Incomplete/	/Unclear	Part Lo	st/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Maintenance			Part M	oved			
	Heat	Γreat			Countersink	Mislabeled			Positio	ned V	Vrong	_	
	Inspe	ction Strin i	n Tube		Cut Too Short	Misread			Power	Loss/	Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio April-22-13 1:03:10 PM

Work Order ID:

100384

Parent Item:

D3852-041

Parent Item Name:

Rib Assembly

Start Date: 4/22/13

Required Date: 4/22/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3 Basket Hoop		Manufactured	No	ann anderen andre en e e e e e e e e e e e e e e e e e		100	Each	11.0387	0.18	-0.1894737 SM)1	. 0,6 3-09-	68Z 26-	
				Location		Loc Qty	<u>Lo</u>	c Code					
				WA		0.494736							
				9415	7	0.494736							
				WA004	•	10.1052							
				8157	8	0.1052							
				9807		10							
				WA007 7729)4	0.4388 0.4388	~	B977Z2	0.6	682			
D3759-1 Bushing		Manufactured	No			100	Each	316.0000	. 1	1			·
		- -\		<u>Location</u>		Loc Qty	<u>L</u> c	oc Code					
SB106	359 X	3)		WA004		316							
17	-	<i>/</i>)		6648	39	1							
	•			7921		1					M	AL 3-16-1	
				8346		7					,,,		
				8655		20					1.	3-167	15
				8823		3				•	0		
				8978		3							
				9078 9808		11 30							

98756

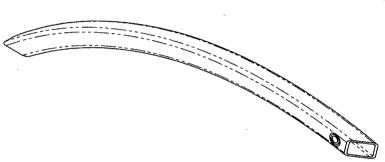
240

NCR:	Yes	1	No

		•								DQA:	Date:				
NCR: Y	es / N	O			WORK ORDER NON	-COI	NFORM	MANCE / UF	PDATE	QA Closed:	Date:				
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS				
Part N NCR N	o				Rework Scrap Use-as-is Work Order Update	Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab					Crosstube Water Jet Engineering Small Fab Prod. Eng. Coor. Quality Finishing Rec/Store/Packaging Othe Composite Supplier				
Root				Descr	ription of work order update		Initial	А	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Cł	nief Eng	Des	cription	Date	Verification	QC Inspector			
ooc/Data quip/Tooling Operator Material etup Other Process Supplier Training Unapproved															
						FAU	LT CATE	GORY	<u> </u>	****					
Landin	Cracks Crush Cuffs Heat 1 Inspec	Not Conce ed/Crimped reat tion Strip in s in Bend	i n Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset		/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	— i	e Waves in		٦	Drawing Finish	-	4 * * * * * *	Calibration Sequence			·				
ŀ		g Sequence Twist in Tu		-	Folio	-	┥	: Dimensions							

	ITEM	QTY -041	Q1Y -042	P/N	DESCRIPTION
	1	_ X		D3852-041	RIB ASSEMBLY
	2		X	D3852-042	RIB ASSEMBLY
			l	1	The state of the s
	3	1	1	D3759-1	BUSHING
٠.	4	1		D3852-1	RIB
[5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

100384 ML3

С

A NEW ISSUE 08.11.07 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D3852 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE RIB ASSEMBLY DE APPR. NTS DATE COPYRIGHT © 2008 BY DART AEROSPACE LTD
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2

NOTES:
1) MATÉRIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

